Date:

Thursday, 3/8/2007 12:37:17 PM

User:

Kim Johnston

Process Sheet

Customer

Prsht Rev.

First Issue

: CU-DAR001 Dart Helicopters Services

Drawing Name

: BUSHING

Job Number

: 31107

: 10173 **Estimate Number**

P.O. Number This Issue

MIM:

NIA

: 3/8/2007

S.O. No. : NA

Part Number

: D2537

Drawing Number

: D2537 REV A1 : N/A

Type : MACHINED PARTS Project Number **Drawing Revision**

: A1

: 29536 Previous Run

Written By .

Material

Due Date

:NIA : 3/30/2007

Qty:

80 Um:

Each

Checked & Approved By

Comment

: Est D 05.01(3/

Material change on Step 2 KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304R500

0.500" 304 SS roundbar



Comment: Qty.:

0.1203 f(s)/Unit Total:

9.6264 f(s)

Material: AISI 304/316 Round Bar Ø0.500"(M304R.500)

Batch: 103007



84

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA273

2-Deburr and Tumble

3.0

QC2

QC8

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK







Comment: SECOND CHECK

5.0

4.0

PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



Page 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	STEP PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
				\triangle			16/22			

Part No:	PAR #: Fault Category:		NCR: Yes No DQA: 🔀	Date: 07/05/02
			QA: N/C Closed:	Date:
NCD.		WORK ORDER NON-CON	FORMANCE (NCR)	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
		4,								
	1 11									

NOTE: Date & initial all entries

Date: User:

Thursday, 3/8/2007 12:37:17 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 31107

Part Number: D2537

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE







Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



107/05/02 Le 84050Z

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
No. of Control of Cont							
Part No	:	PAR #: Fault Category: NC	R: Yes	No DQ	A :	Date:	

QA: N/C Closed: ____ Date: __

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
•		Description of NC		Corrective Action Section B		Verification	A	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto	
		,							
				·					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31107
Description: Bushing	Part Number:	D2537
Inspection Dwg: D2537 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	+/-0.010	1.252	<u></u>			
0.316	+0.005/-0.000	.371				
Ø0.438	+0.005/-0.000	. ५५१				
32						
100		,				
		,				

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 07.00,29	Date: 07/01/29	Date:	N/A

	Rev	Date	Change	Revised by	Approved
	٠A	03.11.11	New Issue	KJ/RF	
	В	05.02.17	Added Ø0.438	KJ/JLM	
_				7 7 7	7-7-





***************************************	DESIGN B WILLIAMS	DRAWN BY B WILLIAMS		AEROSPACE			
	CHECKED	APPROVED	DRAWING NO.			REV	. A
	m.m.	BW	D2537		SHEET	1 0	F 1
	DATE		TILE			SC	N.E
	96:05:15		BUSHING				1:1

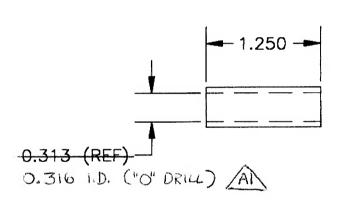
0,316 WAS 0,313

02.08.30 (1)

Al







SHOP COPY RETURN TO

MATERIAL: 304/316 SS 7/16 OD 0.063 WALL

OR 0.065 WALL

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

KE 91.09.07 WITHOUT NOTICE

ENGINEERING

WORK ORDER